October-29-13 10:09:03 AM

Quality Control

Item ID: Revision ID: Item Name: Start Date: Required Date:	D3912-5 Eyebolt Plate 10/29/13 10/29/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*	Accept	*N900  Cust Item Customer:	ID:	100	)* s	Setup Sta	I VI	S1* S2*
Approvals:		:: MLD				ate:		F	Run Sta Sto	\[\]	R1*
Sequence ID/ Work Center II		Operation Description	Date:	Set Up/ Run Hours	Tool ID	Tool #		Accept Qty	Reject Qty	Reject Number	R2* Insp. Stamp
Draw Nbr		sion Nbr									- NETT
D3912	В										
100				0.00							
*100* Waterjet		Memo		0.00				_/8		<u> </u>	JM13-11-15
FLOW CNC Waterj	et	Cut as per of Prog Rev:_ Dwg Rev:_	_B								
-		Deburr as r	equired								
110		QC2- Inspect parts off n	nachine FAI/FAIB	0.00							
*110* QC		Memo		0.00				18	٥		Jm13-11-15

DQA:			Date:			_								*	$\mathcal{L}_{\mathcal{A}}$
QA Closed:			Date:			WORK ORDER NON	l-C	ONFO	RMANCE / I		Mork C	order ur	odate only		AEROSPACE
QA Closed.			Date.								VVOIRC	nuer up	date offy	<u> </u>	
Work Orde	r.					DISPOSITION				AGAINST	DEPAR	TMENT	/PROCESS		
Work Orde	-					Rework	7		Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap	1		Machining	Small Fab	$\dashv$	Pro	d. Eng. Coor.	$\vdash$	Quality
	_					Use-as-is	1		noforming	Finishing	→         F		re/Packaging		Other
NCR N	lo.					Suspected Unapproved	1		Large Fab	Composite	<b>-</b>   `	.00,010	Supplier		
	-					' -	_							L	<b>L.</b> l
Root		-			Desc	ription of work order update		Initial	A	ction	Si	gn &			
Cause		Date	Step	Qty		or non-conformance	Ct	nief Eng	Des	scription	[	Date	Verification	n n	QC Inspector
Design							П								
Doc/Data															
Equip/Tooling	_														
Handling/Pre	[														
Material	_														
Operator	_														
Offset/Setup	_														
Process	_					,									
Supplier	$\dashv$														İ
Training															
Transport	-														
Unapproved					<u> </u>										
Landin				·····			FA	ULT CA	TEGORY			·			
Landin	_				F	General	_	l- :		1					
<b> </b>	-	Bending Centre No	at Cansan		<u> </u>	Bend BOM/Route	-	1	Program				ensions	-	Pressure/Forced
}		Cracks	ot Concer	itric	$\vdash$	BOM/Route	-	Grain		:			tolerance	-	Set-up
1	$\dashv$	Cracks Crimp/Kir	ak/Pinnla	Mayo	-	Broken/Damage/Defect	$\vdash$	Hardwa		(1.6° a a)	_	Incorred		$\vdash$	Temperature/Cure
<b> </b>	$\neg$	Cuffs	IK) KIPPIE	/ vvave	$\vdash$	Burrs	-	1 '	ion Incomplete/	·		Lost/Mi	•	-	Weld
<u> </u>	-	Crushing			-	Contamination	-	1	tions Incomplete		_	Moved		Ш	Wrong Stock Pulled
[		Heat Trea	ıt		-	Cut Too Short	$\vdash$	Mislabe	gned/off center	I	_	tioned V	-		O. h
	_	Inspection		Tube	-	Drawing	$\vdash$	Misread			Pow	er Loss/	ourge	Ш	Other
	$\neg$	Marks/Ch	٠,		$\vdash$	Drill Holes	-	Off-set					·		
		Turning S				Finish	$\vdash$	1	Calibration						
		Wave/Tw		e		Fit/Function	-	4	Sequence			<del> </del>		<del></del>	

Page 2

Insp.

October-29-13 10:09:03 AM Item ID: D3912-5 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Eyebolt Plate 10/29/13 Start Otv: 8.00 **Start Date: Cust Item ID: Req'd Qty:** 8.00 Required Date: 10/29/13 **Customer:** Reference: Run Process Plan: Date: **Tooling:** Date: Approvals: Stop Date: SPC (Y/N): QC: Date: Tool ID Sequence ID/ Operation Set Up/ Tool # Plan Accept Reject Reject Work Center ID Description Code Qty Qty Number Stamp Run HoursAS 120 QC8- Inspect parts - second check 0.00 \*120\* Memo Quality Control Identify as per dwg & Stock Location: 57/44 \*130\* 0.00 Packaging Memo Packaging 0.00 QC21- Final Inspection - Work Order Release 0.00 Memo Quality Control

13/11/199, pl/3/11-18

DQA:		_ Date:			_							ADT
					WORK ORDER NON-	-CO	NFOI	RMANCE / UPD	ATE			AEROSPACE
QA Closed:		Date:							W	ork Order up	date only	
Work Order	r·				DISPOSITION	ŀ			AGAINST DE	PARTMENT	PROCESS	
Trofit Graci	·			_	Rework	1		Skid-tube (	Crosstube	]	Water Jet	Engineering
Part No	0.				Scrap			<b>⊢</b>	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is			noforming	Finishing	1	e/Packaging	Other
NCR No	0				Suspected Unapproved			Large Fab C	omposite		Supplier	
									-	•• 		
Root				Desc	ription of work order update	lr	nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Chi	ef Eng	Descripti	ion	Date	Verification	n QC Inspector
Design	_											
Doc/Data	_											
Equip/Tooling									·			
Handling/Pre	_											
Material	_											
Operator												
Offset/Setup	_					ļ						
Process										1		
Supplier	-											
Training	-											
Transport	-					ļ						
Unapproved		1		L		FALL	II T CAT	L FEGORY		<u> </u>		
Landing	g Gear				General	FAU	JET CA	IEGORT				
[	Bending				Bend		Folio/B	Program		Outside Dim	onsions [	Pressure/Forced
-	<b>⊣</b>	ot Concer	ntric	-	BOM/Route	-	Grain	TOGITATI		Over/Under	ŀ	Set-up
-	Cracks				Broken/Damage/Defect	Н	Hardwa	ıre	-	Part incorred	ł-	Temperature/Cure
	<del></del> -	nk/Ripple	/Wave	-	Burrs	$\vdash$		ion Incomplete/Unqua	alified	Part Lost/Mi	<u> </u>	Weld
	Cuffs	, 15.00	,		Contamination	-		tions Incomplete/Uncl	<del></del>	Part Moved	331116	Wrong Stock Pulled
F	Crushing				Countersink	-		ned/off center	<u> </u>	Positioned V	L /rong	virong stock i uned
	Heat Tre				Cut Too Short	-	Mislabe			Power Loss/		Other
	<del></del> 1	n Strip in	Tube		Drawing	$\boldsymbol{\vdash}$	Misread		<b>L</b>	1	0- <u>[</u>	1
	Marks/C	-			Drill Holes	-	Off-set					
	Turning 5	Sequence			Finish	Н		Calibration				
ı	Wave/Tv	vist in Tub	e e		Fit/Function	П	Out of 9	Sequence				

# **Picklist Print**

October-29-13 10:09:02 AM

Work Order ID:

108831

Parent Item:

D3912-5

Parent Item Name:

Eyebolt Plate

Start Date: 10/29/13

Required Date: 10/29/13

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP RevA: new issue DD 09.11.17 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	207.0633	0.05125	- <del>0.43157</del> 92	>	J	m13-11-15
				Location		Loc Qty	<u>Lo</u>	oc Code					

Location	Loc Qty	Loc Code	
MAT020	207.0632632		
122521	19.1432632		
124445	43.5		
M126075	144.42		126075

Page 1

DQA:		- Date:			. WORK ORDER NON	~	ONICO	DAABICE / LI	IDDATE				1.2	DART	
QA Closed:		Date:			WORK ORDER NON-	-C(	JNFOI	RIVIANCE / U	PDATE	Wo	ork Order up	date only	$\neg$	AEROSPACE	
Work Orde	ar:				DISPOSITION				AGAINST	DE	PARTMENT,	PROCESS			
Part N	No				Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jei Prod. Eng. Coor Rec/Store/Packaging		E	ngineering Quality Other	
NCR I	No				Suspected Unapproved			Large Fab	Composite			Supplier			ı
Root		6.		Desc	ription of work order update	l	Initial		tion		Sign &				
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification		QC Inspector	-
Design															l
Doc/Data Equip/Tooling								-					.		
Handling/Pre															
Material													ŀ		
Operator															
Offset/Setup															
Process															
Supplier															Ì
Training															l
Transport															
Unapproved															l
			1			FAI	ULT CA	EGORY			<u> </u>				1
Landi	ng Gear				General							·········			1
	Bending				Bend	Г	Folio/F	rogram			Outside Dim	ensions [	Pre	ssure/Forced	
	Centre N	ot Concer	ntric		BOM/Route	Г	Grain				Over/Under	tolerance	Set	t-up	
	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorred	t F	Ter	nperature/Cure	
	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	on Incomplete/U	nqualified		Part Lost/Mi	ssing	− We	•	
	Cuffs				Contamination		Instruct	ions Incomplete/	Unclear	-	Part Moved			ong Stock Pulled	
	Crushing				Countersink		Misalig	ned/off center			Positioned W	/rong		•	
	Heat Trea	at			Cut Too Short		Mislabe	led			Power Loss/S	Surge [	Oth	ner	
	Inspectio	n Strip in	Tube		Drawing		Misread	I	•		•	_			1
	Marks/Cl	hatter			Drill Holes		Off-set							·-··	1
	Turning S	Sequence			Finish		Out of (	Calibration							1
	Wave/Tv	vist in Tub	e		Fit/Function	Γ	Out of	equence							1

DART AEROSPACE LTD	Work Order:	108831
Description: Eyebolt Plate	Part Number:	D3912-5
Inspection Dwg: D3912 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.129"	_		V	Thmol
Ø0.257	+0.006-0.001	0 358	-		υ	
0.38	+/-0.030	0.384"			ر	
1.500	+/-0.010	1.503			J.	
0.500 Pitch	+/-0.010	0.505	_		7	
3.15	+/-0.030	3.15"	-		v	
0.375	+/-0.010	0.376"			V	
0.517	+/-0.010	0.519	_		V	
1.000	+/-0.010	1.004"	_		_ U	
3.65	+/-0.030	3654	1		. U	
1.500	+0.020/-0.000	1.500			V	
0.25	+/-0.030	8,25	-		U	
2.00	+/-0.030	2.007	•		7	
0.125	+/-0.010	2.116			L	
	,					
			DAS			

			27		
Measured by:	Im	Audited by:	9-89	Preliminary Approval:	
Date:	13-11-15	Date:	13/11/18	Date:	

Rev	Date	Change	Revi	sed b	у	Appro	oved
Α	10.06.07	New Issue	KJ	1	^	1.1	
В	10.08.09	Dwg Rev updated	KJ	- de		1 1/4	
					7		

_	,	<b>•</b> 8	1	7	6	5	. 4	3	2
ITI	EM	QTY -041	P/N	DESCRIPTION					
		X	D3912-041	EYEBOLT RECEIVER ASSY					
-	1	1	D3912-1	EYEBOLT		*			
	2	2	D3912-3	EYEBOLT BLOCK					
	3	2	D3912-5	EYEBOLT PLATE					$\bigcirc$
_	4	1	D3801-1	SPRING PLUNGER	<u>B</u>		•	1	
- 5	5	-8-	MS20615-4M20	RIVET -	᠆┤				\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\
-	6	1	MS21209-F615	HELICAL				_//	
7	7	1	NAS1149F0332P	WASHER	<u>B</u>				
						3			
•				1		00 6		SUPPLE	MENTAL ISO VIE

IEW (EYEBOLT PLATE REMOVED TO SHOW INTERIOR FEATURES)

13-10-70 13-10-70

#### D3912-041 EYEBOLT RECEIVER ASSY

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING
FINE POINT PERMANENT INK MARKER:

D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1. JPH 10.06.28 NEW ISSUE JPH 10.03.04 Α REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3912 MFG. APPR. SHEET 1 OF 3

APPROVED TITLE EYEBOLT RECEIVER ASSY DE APPR DATE

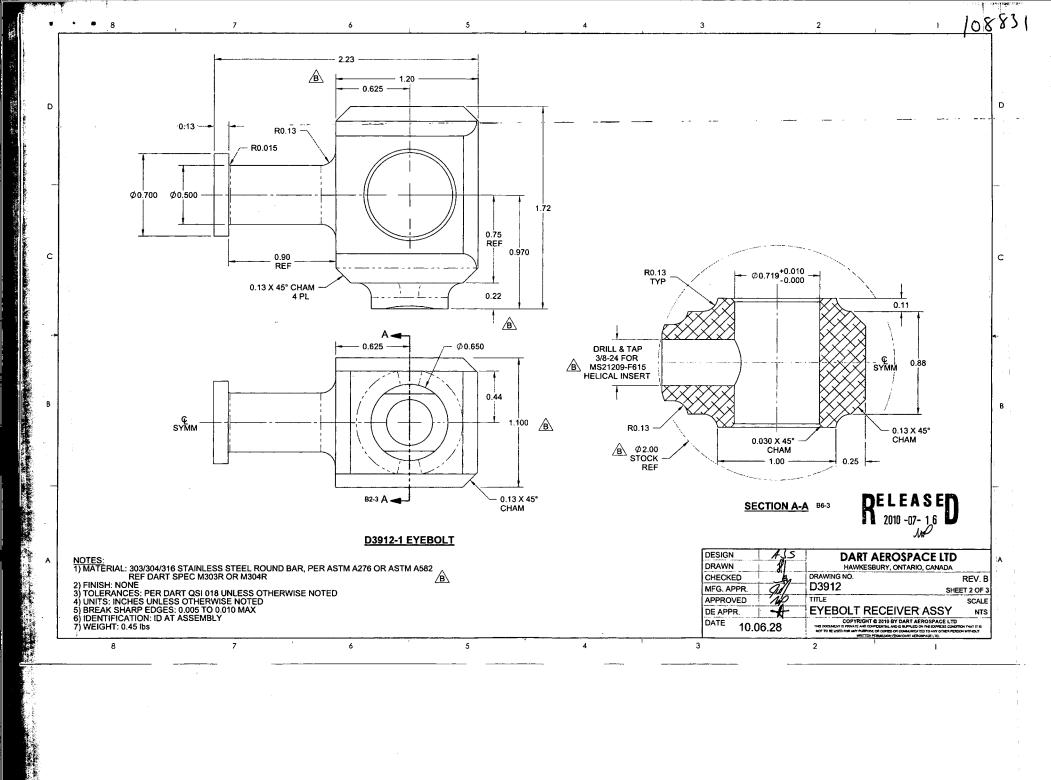
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WINTEN PRIVATES OF PRIVAL DART AEROSPACE LTD. 10.06.28

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SCALE

NTS



108831

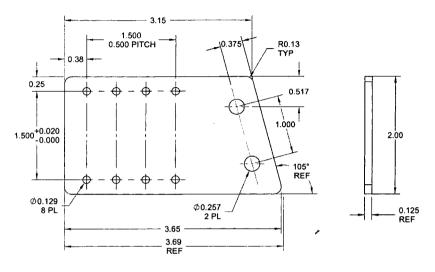
0.800+0.000 2.30 Ø0.129 THRU 1.500 4 PL --- 0.400 --0.500 PITCH 0.50 REF 1.00 0.750+0.000 0.500 R0.13 R0.125 0.516+0.015 0.63

### **D3912-3 EYEBOLT BLOCK**

NOTES: 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
  3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
  4) UNITS: INCHES UNLESS OTHERWISE NOTED
  5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  6) IDENTIFICATION: ID AT ASSEMBLY
  7) WEIGHT -3: 0.30 is
  -5: 0.24 lbs



### **D3912-5 EYEBOLT PLATE**

RELEASED 2010 -07- 16

			i
DESIGN	AS5	DART AEROSPACE LTD	1
DRAWN	181	HAWKESBURY, ONTARIO, CANADA	
CHECKED	_\$,	DRAWING NO.	REV. B
MFG. APPR.	all	D3912 <sub>SH</sub>	EET 3 OF 3
APPROVED	119	TITLE	SCALE
DE APPR.	-#-	EYEBOLT RECEIVER ASSY	NTS
DATE 10.0	6.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE DIPRESS COM NOT TO BE USED FOR ANY PURPOSE OR COPYED OR COMMUNICATED TO ANY OTHER PER	STITLET HOTE